

# Work Order ID 73047

Wednesday, August 24, 2011 3:34:05 PM



Page 1

Item ID: D120-638-011 *18*

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 8/25/2011 Start Qty: 4.00

Required Date: 9/8/2011 Req'd Qty: 4.00 *2*



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *me*

Date: *11-08-24*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

*S 11/09/19*

*Jefar BG 11-9-16*

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*SP 11-09-16 (2)*

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*S 11/09/19*

*(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73047**

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Item ID: D120-638-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 8/25/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD120-638-011

Location: 13 Reo A11/19/11 20

190

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/19/11MF  
11-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 24, 2011 3:34:02 PM

Page 1

Work Order ID: 73047

Parent Item: D120-638-011

Parent Item Name: Bearpaw



Start Date: 8/25/2011

Required Date: 9/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC  
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2435		Manufactured	No			160	Each	1.0000	2	84 689F3			
Bearpaw, 206													

Location Loc Qty Loc Code

ST497 1  
63785 1

D2182B050		Manufactured	No			160	Each	31.0000	4	16			
Clamp Cushion Black													

Location Loc Qty Loc Code

ST402 31  
66063 15  
70988 16

D2274		Manufactured	No			160	Each	712.0000	8	32			
Radius Block													

Location Loc Qty Loc Code

ST010 299  
69736 200  
69773 99  
ST011 413  
72121 413

69736

64/3/19 (4)

52

✗

5 + 2 4 + 4 per kit @ 5.0" only → needed 8/12/15

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 24, 2011 3:34:02 PM

Page 2

Work Order ID: 73047

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Start Date: 8/25/2011

Required Date: 9/8/2011

Start Qty: 4.00

Required Qty: 4.00

D2438

Manufactured No

160

Each

222.0000

4

16



Clamp

Location

Loc Qty

Loc Code

ST456

222

68673

24

69737

108

70693

90

D2529

Manufactured No

160

Each

421.0000

8

32



Washer

Location

Loc Qty

Loc Code

ST016

421

66953

171

71161

250

AN4-15A

Purchased

No

160

Each

359.0000

8

32



Bolt

Location

Loc Qty

Loc Code

ST358

359

118112

59

118648

300

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

0.0000

8

32



Washer

m118384 32x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Wednesday, August 24, 2011 3:34:03 PM

Work Order ID: 73047



Parent Item: D120-638-011



Parent Item Name: Bearpaw

Start Date: 8/25/2011

Required Date: 9/8/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

4,359.000

8

32



8/11-09-16. *[Signature]*

Nut

Location

Loc Qty

Loc Code

ST300

4359

117441

214

117601

645

~~117885~~

1500

118451

2000

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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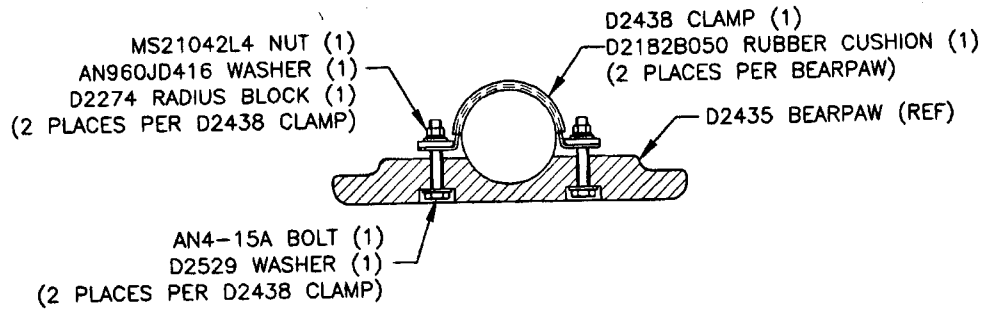


Figure 2 – Bearpaw Installation

**4. WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

**5. PARTS LIST**

Qty	Part Number	Description
<b>X</b>	<b>D120-638-011</b>	<b>BEARPAW INSTALLATION</b>
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)